

Work Order ID 165300 -2

Monday, August 21, 2017 10:19:53 AM

165300

Page 1

Item ID: D3591-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Bushing

Start Date: 8/21/2017 Start Qty: 10.00

Required Date: 8/21/2017 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3591

Rev B

100

0.19

100

Hardinge

Hardinge CNC Lathe Small

CONVENTIONAL LATHE

Memo

0.39

1-Turn as per dwg D3591 (Ream extrusion if nessasary to obtain ID tolerance per QSI 18)

2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.10

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.20

DAS

32

9-89

17-08-31

DAS

32

9-89

17-08-31

DAS

44

9-89

17-08-31

Work Order ID 165300***165300***

Page 2

Monday, August 21, 2017 10:19:53 AM

Item ID: D3591-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 8/21/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/21/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP001</u> Memo LOCATION : FP001	0.00 0.10				<u>X9</u>	<u>d</u>	<u>lll</u>	<u>17/07/31</u>
140 *140* QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 1.00							<u>17/9/16</u> <u>JD</u>

um

AUG 31 2017

Picklist Print

Page 1

Monday, August 21, 2017 10:19:51 AM

Work Order ID: 165300

165300

Parent Item: D3591-1

D3591-1

Parent Item Name: Bushing

Start Date: 8/21/2017

Required Date: 8/21/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 07.02.01 new issue EC
IPP Rev:B 08-09-10 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	67.9088	0.35	3.684211			DAS
M304TR0 500W 035												17-08-31	32
													9-89

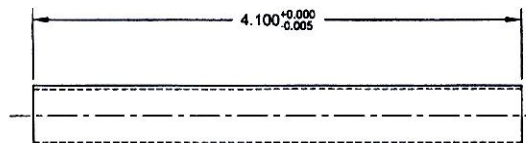
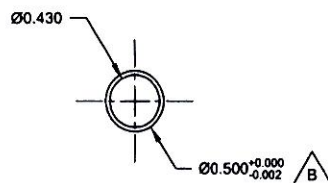
304 RD Tube .500 x .035W

Location	Loc Qty	Loc Code
GA	67.908796	
m137086	12.843477	
m137199	2.300579	
m137286	0.02674	
m137415	26.418	
m137623	1.55	
m137834	24.77	
M138 403		

0.6980

2.444

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165300 MGS
120821



D3591-1 BUSHING

RELEASED
08-09-2016

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
REF. DART SPEC M304TR0.500W.035
OR: AISI 303/304/316 SS, ROUND BAR
REF DART SPEC M303R/M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MAINTAIN TOLERANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)	AJS	08.08.25
A	NEW ISSUE	PH	07.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3591	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING	NTS
DATE	08.08.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	